



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3814
Job Sheet 168254



Part No: 646.3814

Job Qty: 4 ea

Part Name: Wiper Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/21/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV n/c IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/20/17	0.00	0.00	Start Up Container		ML
105	Bandsaw	4 pcs		11/20/17	0.00	0.00	Bandsaw1		SC
110	CNC Vertical Machining	4 pcs		11/21/17	0.00	3.02	HAAS 1		ML
120	QC	4 pcs		11/21/17	0.00	0.00	QC2		11
130	QC	4 pcs		11/21/17	0.00	0.00	QC8		
140	Outsource	4 pcs		11/21/17	0.00	0.00	Outsource4		ML 12-1-18
150	Packaging	4 pcs		11/21/17	0.00	0.00	Packaging2		ML 12-1-18
160	QC	4 pcs		11/21/17	0.00	0.00	QC5		ML 12-1-17
170	Packaging	4 pcs		11/21/17	0.00	0.00	Packaging3		ML 12-1-17
180	QC21-SA	4 Ea		11/21/17	0.00	0.00	QC21		ML 12-1-17

Part Op 105 - Cut blank at 2.200"

Descriptions: 110 - 1-Machine as per folio FB539 DWG REV: n/c 2- Deburr and break all sharp edges

140 - Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required

170 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6B0.750X1.250	1	0	0	0

M137300-179.750 x 2.000

- 74 ft + 1.00

Part Specifications

5022721

Specifications could not be found.

Plex 11/14/17 7:17 AM dart.boucher.sylvie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



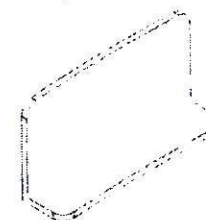
QA Closed: _____ Date: _____

Work Order update only ☐

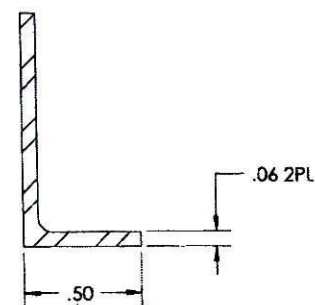
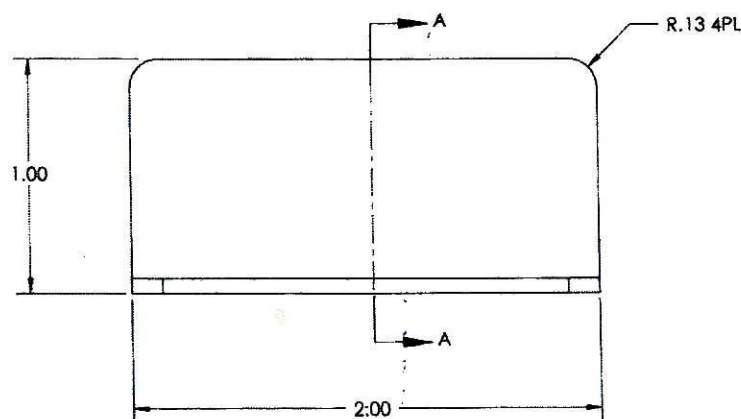
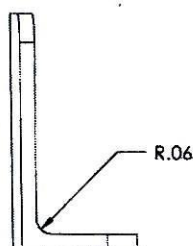
Work P _____ N _____ Date: _____ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Sk _____ Ma _____ Thermo _____ Lk _____ Q _____ Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		neering ☐ Quality ☐ Other ☐ 51042) Approval	
646.3814 Start up Operation Mfg Date: 12/15/17 Job No: 168254		646.3814 Outsource Mfg Date: 12/15/17 Job No: 168254		Completed By and / Supervisor oval Verification	
646.3814 Start up Operation Mfg Date: 12/15/17 Job No: 168254		646.3814 Outsource Mfg Date: 12/15/17 Job No: 168254		QA Coordinator Approval	
Envirc _____ Do _____ Equip/T _____ Handli _____ M _____ Internal Tra _____ Tribal Know _____ DART AEROSPACE S022785 Wiper Bracket PART NO: Revision: Operation: Change No:		Tempe _____ Set-up _____ BOM/ _____ Broke _____ Inspec _____ Conta _____ Coun _____ Cut Too Short _____ Instructions Incomplete/Unclear _____ Drill Holes _____ DART AEROSPACE S022785 Wiper Bracket PART NO: Revision: Operation: Change No:		sitioned Wrong itside Dimensions er/Under tolerance rt Incorrect rt Lost/Missing art Moved rawing inish Misread Turning Sequence	
Substation _____ Past Expiry Date _____ Misidentified _____		Product Improvement _____ Process Improvement _____ Manufacturing Process _____ Past Due _____		Wave/Twist in Tube Marks/Chatter OTHER :	

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REVISION			
REV	DESCRIPTION	DATE	APPROVED



646.3814



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 168254

DAS
30
9-89

NOV 16 2017

NEXT ASSY (S)	ORIGINAL DATE	08-19-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 BRACKETS	
	DESIGNED BY	08/07/08		
	DRAWING APPROVAL			
	CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED		50% (CAGE CODE)	DWG NO.	REV
DIMENSIONS ARE IN INCHES		6	074126	646.3800
2 PLACE DECIMALS		SCALE	NONE	N/C
3 PLACE DECIMALS		SHEET 5 OF 5		
ANGLES ± .5°				

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038682

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
14	168254	646.3814	649.5200 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required Wiper Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	1/17/18	4 pcs	0 pcs	4 pcs	\$7.10/pcs	\$28.40
15	169450	647.0310	Channel Issue P/O to ATG : Hard Anodize Black / Prime as per Dwg 647.0300	Firmed	1/17/18	30 pcs	0 pcs	30 pcs	\$12.10/pcs	\$363.00
16	169391	647.7823	Cross Bracket Aft Issue P/O to ATG :	Firmed	12/22/17	10 pcs	0 pcs	10 pcs	\$12.25/pcs	\$122.50
Line Item Note RUSH										
17	169009	RBT18601	Main Rotor Swashplate ReGreasing Tool -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2 Water seal -Certificate of Conformity is required	Firmed	1/17/18	6 pcs	0 pcs	6 pcs	\$26.00/pcs	\$156.00
18	169224	RB910-0003-1	Quill -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant As Per DWG RB910- 0003-1 Rev. 5	Firmed	1/17/18	3 pcs	0 pcs	3 pcs	\$6.20/pcs	\$18.60
19	169418	RBD29936	Tail Rotor Bungee Tool -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity	Firmed	1/17/18	3 pcs	0 pcs	3 pcs	\$6.20/pcs	\$18.60



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914369

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 615 632-9377 Fax: 615 632-9377		OUR TRUCK	
Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 649.4814 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22189		Rev: D PO: PO038682 Line: 1
4 ea	Part: 646.3814 Wiper Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22202		Rev: N/C PO: PO038682 Line: 14
8 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22190		Rev: N/C PO: PO038682 Line: 2
5 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22191		Rev: N/C PO: PO038682 Line: 3
5 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22191		Rev: N/C PO: PO038682 Line: 3
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914369

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	OUR TRUCK
Quantity	Description
	- .9 mils) per drawing. Job: 22192 PO: PO038682 Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>05/01/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>8018-01-11</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.	



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: 646.3814 Revision: Wiper Bracket														
180	QC21-SA	S022785	168254	4 Ea	0	S022785	CCK105		Stock	12/15/2017	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Part Number: M7075T6B2.000X00.750 Revision: 7075-T6 Bar 2.000' X 0.750"														
100	Receive Ft	S022721	168254	0 ft	0		Start Up Container		Stock	12/15/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		4	0									

Plex 1/19/2018 6:07 AM Dart.Lajeunesse.Marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									